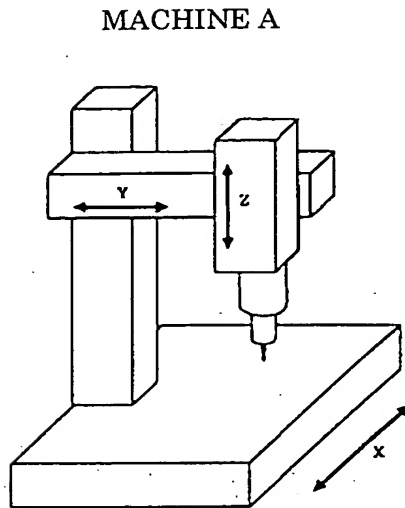
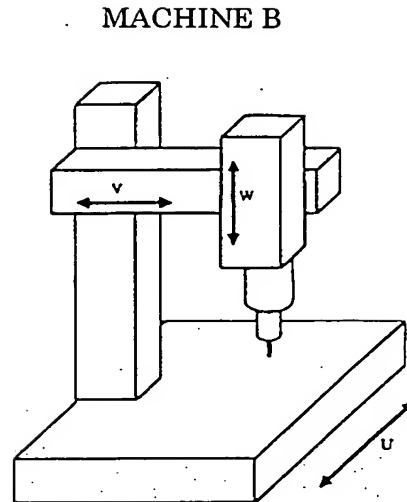


FIG. 1A



CONTROLLED AXIS NUMBER	AXIS ADDRESS
1	X
2	Y
3	Z

FIG. 1B



CONTROLLED AXIS NUMBER	AXIS ADDRESS
1	U
2	V
3	W

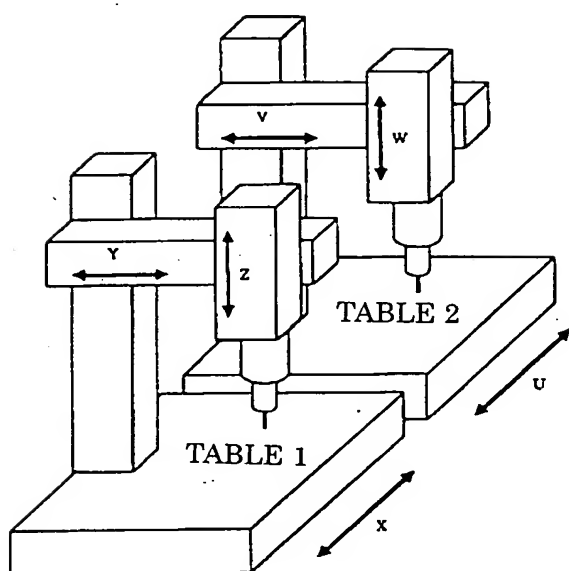
FIG. 2A

```
O0010 (MACHIN-A);  
N001 G92 X0 Y0 Z0;  
N002 G90 G00 Z250.0 T11 M06;  
N003 G43 Z0 H11;  
N004 S30 M03;  
N005 G99 G81 X400.0 Y-350.0 Z-153.0 R-97.0 F120;  
N006 Y-550.0;  
N007 G98 Y-750.0;  
N008 G99 X1200.0;  
N009 Y-550.0;  
:  
:
```

FIG. 2B

```
O0020 (MACHIN-B);  
N001 G92 U0 V0 W0;  
N002 G90 G00 W250.0 T11 M06;  
N003 G43 W0 H11;  
N004 S30 M03;  
N005 G99 G81 U400.0 V-350.0 W-153.0 R-97.0 F120;  
N006 V-550.0;  
N007 G98 V-750.0;  
N008 G99 U1200.0;  
N009 V-550.0;  
:  
:
```

FIG. 3



CONTROLLED AXIS NUMBER	AXIS ADDRESS
1	X
2	Y
3	Z
4	U
5	V
6	W

FIG. 4A

```
O0030 (TABLE1);  
N001 G92 X0 Y0 Z0;  
N002 G90 G00 Z250.0 T11 M06;  
N003 G43 Z0 H11;  
N004 S30 M03;  
N005 G99 G81 X400.0 Y-350.0 Z-153.0 R-97.0 F120;  
N006 Y-550.0;  
N007 G98 Y-750.0;  
N008 G99 X1200.0;  
N009 Y-550.0;  
:  
:
```

FIG. 4B

```
O0040 (TABLE2);  
N001 G92 U0 V0 W0;  
N002 G90 G00 W250.0 T11 M06;  
N003 G43 W0 H11;  
N004 S30 M03;  
N005 G99 G81 U400.0 V-350.0 W-153.0 R-97.0 F120;  
N006 V-550.0;  
N007 G98 V-750.0;  
N008 G99 U1200.0;  
N009 V-550.0;  
:  
:
```

FIG. 5

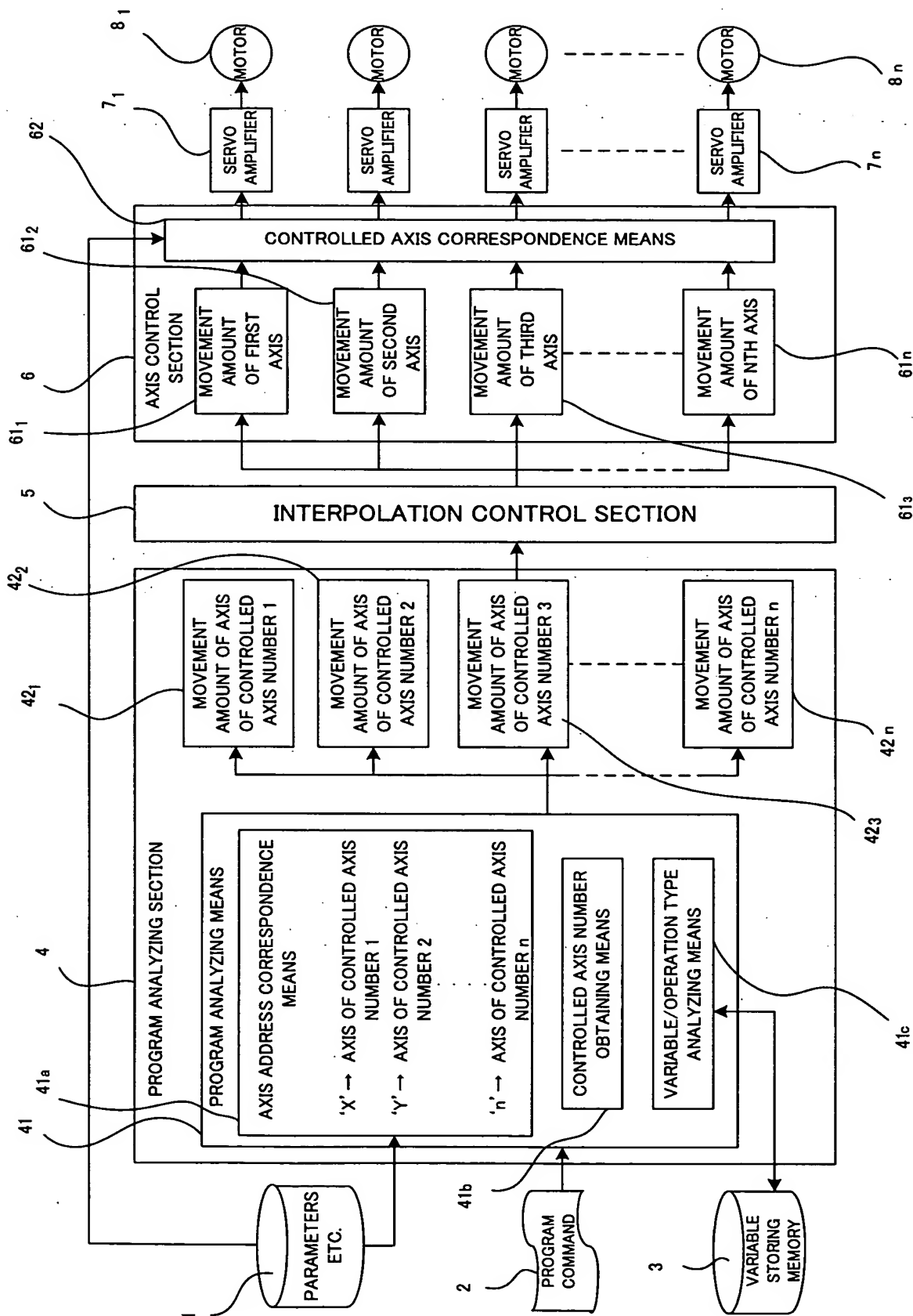


FIG. 6

```
O0060(MACHIN-A&B);  
N001 G92 AX[1]=0 AX[2]=0 AX[3]=0;  
N002 G90 G00 AX[3]=250.0 T11 M06;  
N003 G43 AX[3]=0 H11;  
N004 S30 M03;  
N005 G99 G81 AX[1]=400.0 AX[2]=-350.0 AX[3]=-153.0 R-97.0 F120;  
N006 AX[2]=-550.0;  
N007 G98 AX[2]=-750.0;  
N008 G99 AX[1]=1200.0;  
N009 AX[2]=-550.0;
```

FIG. 7

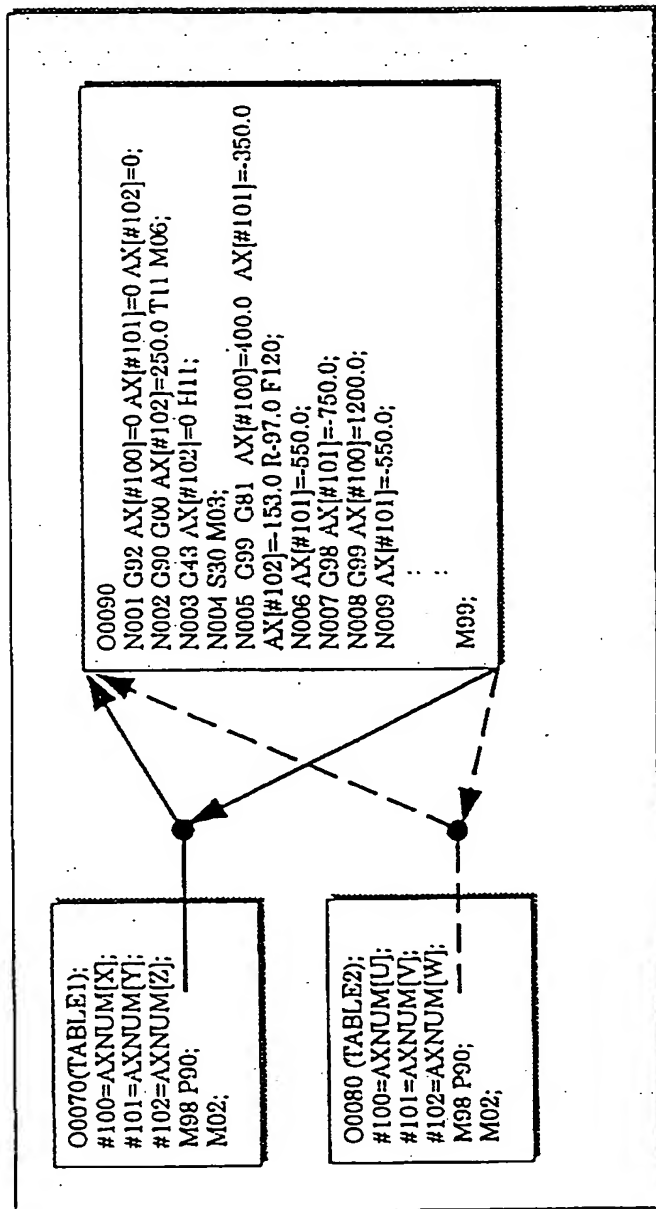


FIG. 8

```
O0050 (REPEAT AXIS);  
N001 G92 X0 Y0 Z0 U0 V0 W0 A0 B0 C0;  
N002 G90 G01 F1000;  
N003 X100.0;  
N004 Y100.0;  
N005 Z100.0;  
N006 U100.0;  
N007 V100.0;  
N008 W100.0;  
N009 A100.0;  
N010 B100.0;  
N011 C100.0;  
N012 G00 X0 Y0 Z0 U0 V0 W0 A0 B0 C0;  
:  
:
```

FIG. 9

```
O0100 (REPEAT AXIS);  
N001 G92 X0 Y0 Z0 U0 V0 W0 A0 B0 C0;  
N002 G90 G01 F1000;  
N003 #100=AXNUM[X];  
N004 #101=AXNUM[C];  
N005 #102=0;  
N006 WHILE[ #102 LT #101 ] DO 1;  
N007 AX[#100+#102] = 100.0;  
N008 #102=#102+1;  
N009 END 1;  
N010 G00 X0 Y0 Z0 U0 V0 W0 A0 B0 C0;  
:  
:
```



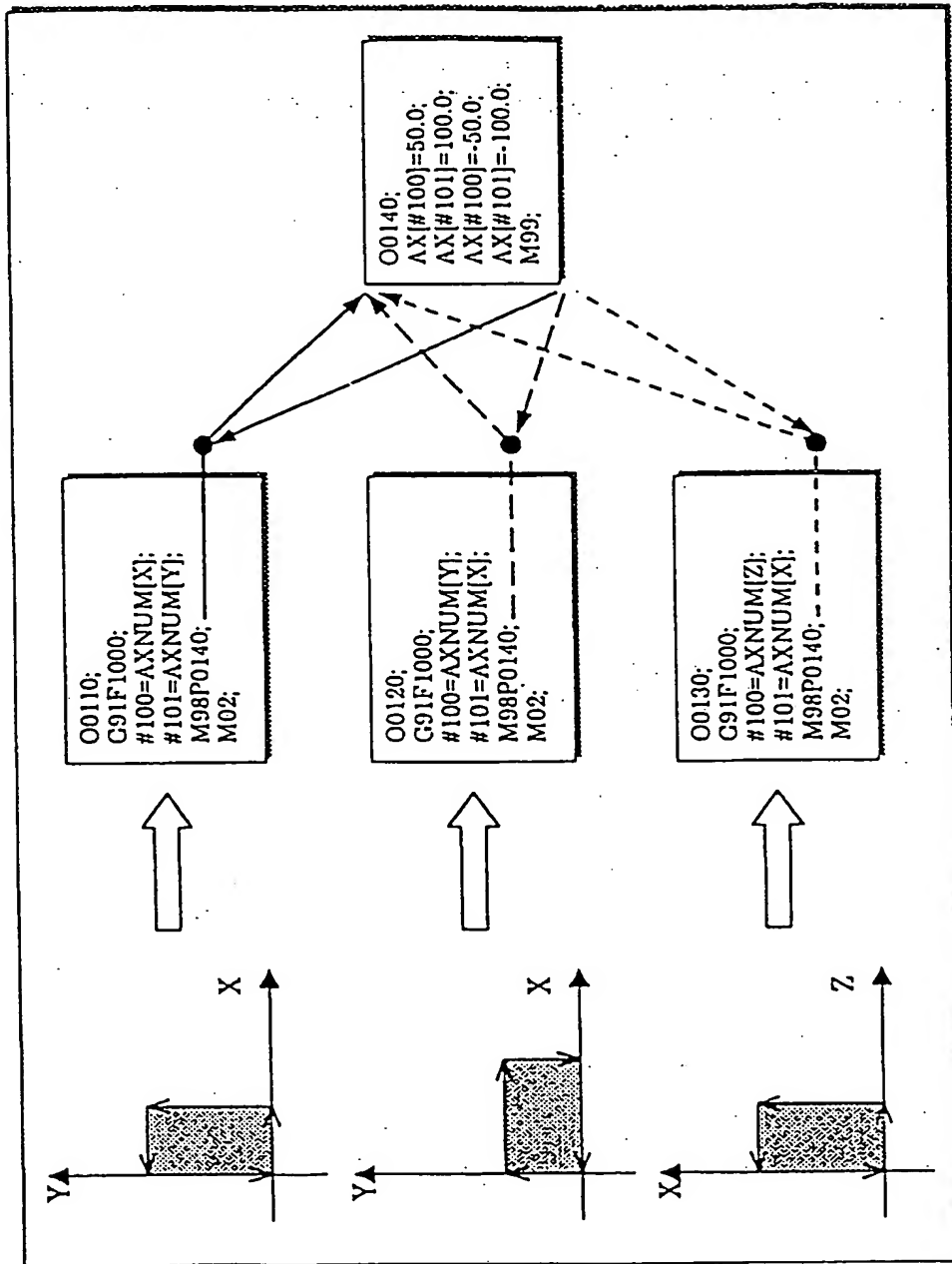


FIG. 11

